

Work Order ID 64998

Wednesday, January 05, 2011 1:16:51 PM



Page 1

Item ID: D3655-3

Accept



Setup Start



Revision ID:

Stop



Item Name: PANEL

Start Date: 1/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/5/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

1-01-5

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3655

Rev B

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to fit frame size

x2

Dh

11/01/07

105

0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: *240°F*

Time IN: *5:30 pm*

Time OUT: *7:00 am*

11/01/06

11/01/07

x2

Dh

11/01/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D3655-3 and Folio FTA 017 using tool DT 8985 □ Dwg. Rev. <u>B</u> □ Folio Rev. <u>C</u>	0.00 0.00				<u>x2</u>			<u>St</u> 11/01/07
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect for proper formation of each part	0.00 0.00				<u>x2</u>			<u>St</u> 11/01/07
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>x2</u>			<u>B</u> 11/01/07

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Required Date: 1/5/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions as per dwg D3655	0.00 0.00				2			B 11/01/11
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Check dimensions to ensure conformity to drawing tolerances.	0.00 0.00				2			B 11/01/11
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(X2)			

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Required Date: 1/5/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

PDP
65526

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

mk
11-01-20

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, January 05, 2011 1:16:56 PM

Page 1

Work Order ID: 64998



Parent Item: D3655-3



Parent Item Name: PANEL

Start Date: 1/5/2011

Required Date: 1/5/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A 07/12/13 New Issue DL verified by:DD
IPP Rev. B 08/09/25 Dwg. Update DL.
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,824.630	34.66	69.32			



GE PLASTICS LEXAN SHEET

Location

therm

Loc Qty

1824.63

Loc Code

107574

6.46

112176

101.2267

114459

1716.9433

69.32 sq ft

11/01/07

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	64998
Description: Panel		Part Number:	D3655-3
Inspection Dwg: D3655	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: B

Date: 11/01/11

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
67.9	+/-0.100	67.9	✓			
25.0	+/-0.100	25	✓			
44.5	+/-0.100	44.55	✓			
0.070	Min	.097	✓			
0.050	Min	.071	✓			

Measured by: B

Date: 11/01/11

Audited by: S

Date: 11/01/13

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ <u>B</u>	<u>M</u>

W/O:		WORK ORDER CHANGES					
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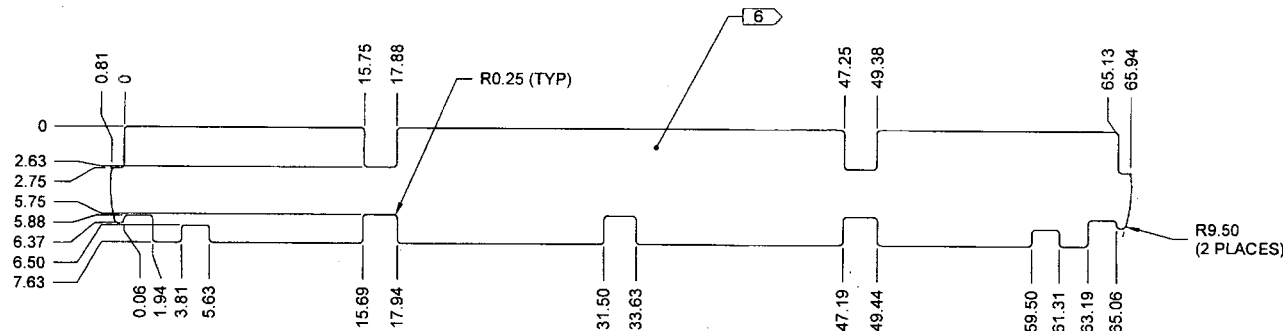
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 44998
BP 11-015



D3655-1 PANEL

RELEASED
08.06.16

D3655-1 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 7) WEIGHT: 1.8 lbs

B	44.5 WAS 45.5 (ZN C8-2); 20.9 WAS 19.8 (ZN D5-2); DELETE REFERENCE DIMENSION 2.4 (ZN D6-2); ADD 30.25 DIMENSION FOR TRIMMING (ZN C3-2); REASON: DRAFTING ERROR	PH	08.06.16
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN	KE		
CHECKED	KE		
MFG. APPR.	KE		
APPROVED	KE		
DE APPR.	KE		
DATE	08.06.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3655 TITLE PANEL REV. B SHEET 1 OF 2 SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. UNLESS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

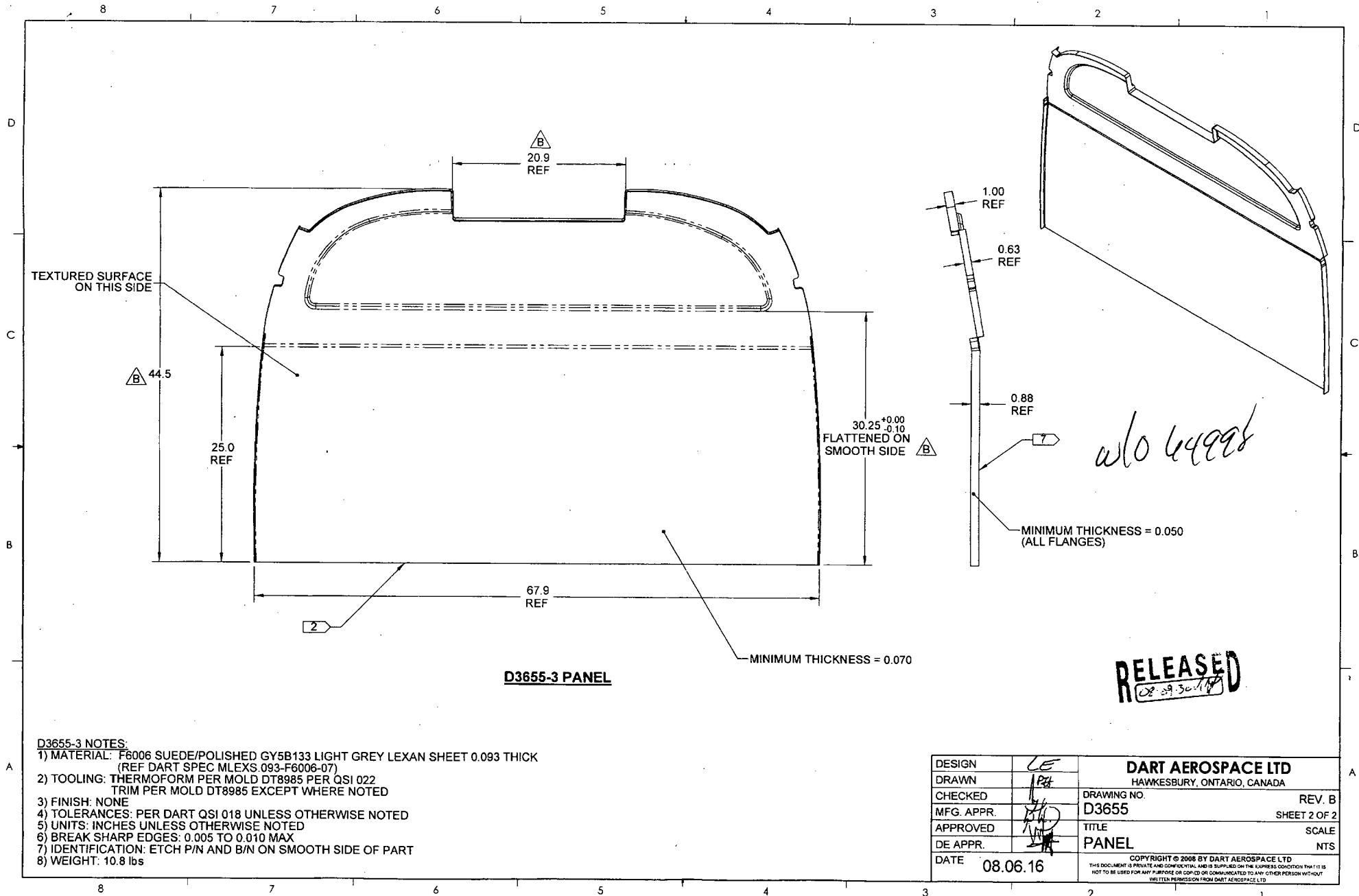
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DESIGN	CE	DART AEROSPACE LTD	
DRAWN	IRB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	IRB	DRAWING NO.	REV. B
MFG. APPR.	IRB	D3655	SHEET 2 OF 2
APPROVED	IRB	TITLE	SCALE
DE APPR.	IRB	PANEL	NTS
DATE	08.06.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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